

Date: Thursday, 2/8/2007 12:06:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 30690	
Estimate Number : 12704	
P.O. Number : N/A	Part Number : D35501
This Issue : 2/8/2007 S.O. No. : N/A	Drawing Number : D3550 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 30637	Material : N/A
Written By : <u>JA</u>	Due Date : 2/15/2007
Checked & Approved By : <u>JA 07.02.02</u>	Qty: 50 Um: Each
Comment : Est. A 07.02.05 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.7850 f(s)/Unit Total : 89.2500 f(s).
 304 RD Tube .500 x .049W
 304/316 Seamless tubing, 1/2" OD x .049 Wall

M103629 19

Batch M102742 28 83 07/03/07

40

49.98

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form per Dwg D3550

FF 07-03-01 47

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

FF 07-03-05 47

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

M 07/03/05 45

5.0	POWDER COATING	POWDER COATING
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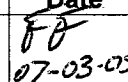

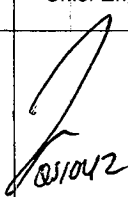



Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M103141 46/0.01 07-03-06 45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/05	3.0	Wedge Flat end 1.8" was to short .200" off	 07/03/05	-destroy two	 07-03-05	 07/03/05	 07/03/05	 07/03/05

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:06:10 PM
User: Kiri Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 30690

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



CP 07/03/08 (45)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/03/08 (45)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(45)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



U 07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

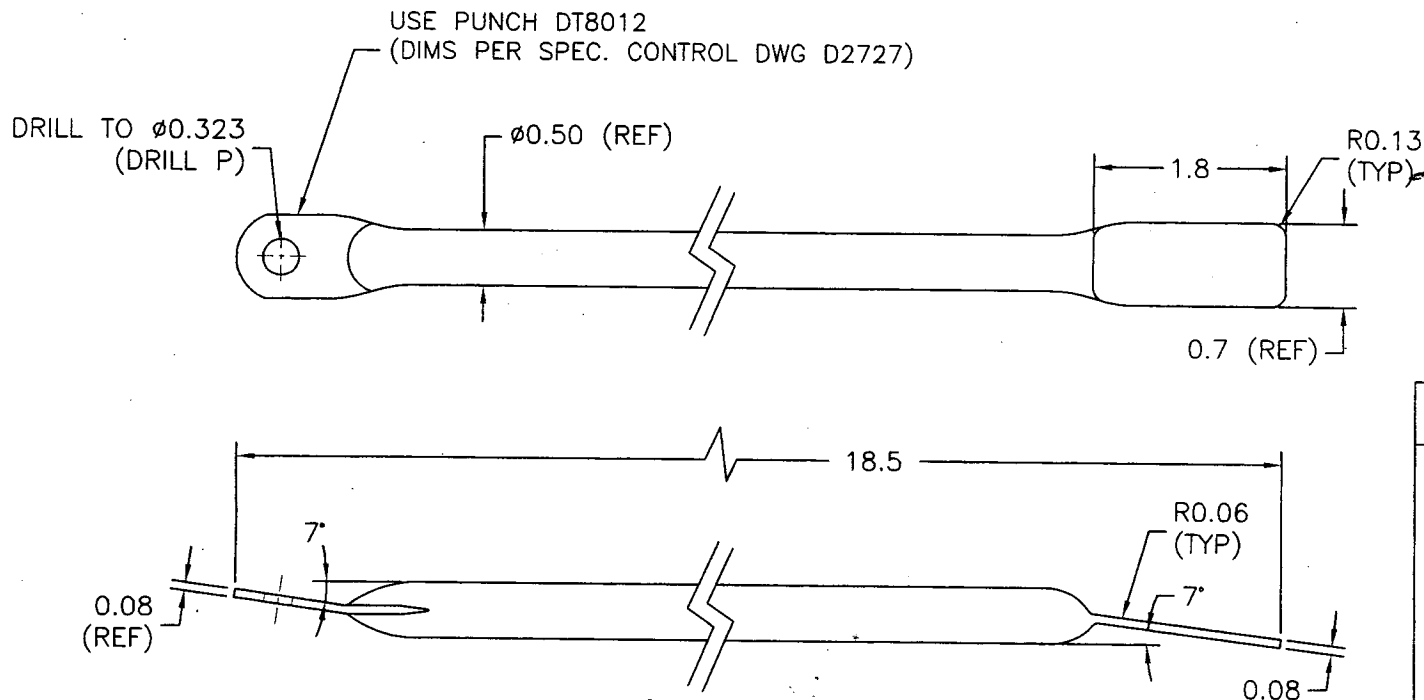
NOTE: Date & initial all entries

UNDER REVIEW

07.02.22 LE

OK to proceed
per [signature]

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CE	CE	DRAWING NO.	REV. B
CHECKED BH	APPROVED	D3550	SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	06.10.24	NEW ISSUE	
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	



D3550-1 STRUT

WIP 30490

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER